



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB23033033
Job Sheet 199597



Part No: RB23033033

Job Qty: 2 pcs

Part Name: Drift Guided Compressor Front Bearing Ring



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/28/19

Job Tracking No:

Due Date: 11/11/19

Created By: Chantal Lavoie

Type: SOLD

Description:

Note: DWG RB23033033 Rev 2 IPP Rev. A 19.08.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup Hrs	Run Hrs		
100	Purchasing	2 pcs	11/11/19	11/11/19	0.00	0.00	Purchasing - 1	HE OCT 25 2019
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	2 pcs	11/11/19	11/11/19	0.00	0.00	Packaging 2 - 1 - B4B	HE OCT 25 2019
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	



Container No: S226584



Part: RB23033033

Job No: 199597

Serial No/Batch: S226584

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/25/19

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					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	2 pcs	11/11/19	0.00 0.00		QC 6 - 9	DAS
					QC 6 - 68	OCT 30 2019 68
					QC 6 - 61	9-89
					QC 6 - 40	
					QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	2 pcs	11/11/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	2 pcs	11/11/19	0.00 0.00		QC 21 - FG - 21	DAS
					QC 21 - FG - 70	21 OCT 31 2019
					QC 21 - SA - 53	9-89

Part Op 100 - (Purchasing) Issue P/O: _____ MANUFACTURE RB23033033 AS PER DWG Supplier: ARROW TECH
 Descriptions: Certificate of conformity is required
 110 - (Receive & Inspect for Damage & Mat'l Certs)
 120 - (QC6- All purchased or subcontracted products)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RB23033033P	DRIFT GUIDED COMPRESSOR FRONT BEARING RING SEAL	2 pcs (1 ea)	100-Purchasing	S226582
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB23033033P	2	0	0
Part Specifications				
Specifications could not be found.				

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PURCHASE ORDER

POHB044334



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To:

PO No: POHB044334
PO Date: 8/23/19
Due Date: 11/11/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com
Pymt Terms: Net 30
Freight Terms:
Special Comments: QUOTE # 332

REVISED

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	199568	RB23003262P			LOCKNUT CRIMPER	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$1,248.45/pcs	\$2,496.90
2	199569	RB23033030P			DRIFT-INSTALLATION COMPRESSOR	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$293.73/pcs	\$587.46
3	199570	RB23033031P			FRONT BEARING HOUSING HOLD FIXTURE	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$427.62/pcs	\$855.24
4	199571	RB23033032P			DRIFT-COMPR.FRONT BEARING OU	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$376.53/pcs	\$753.06
5	199572	RB23033035P			PULLER-COMP FRONT BEARING RING	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$3,230.00/pcs	\$6,460.00
6	199573	RB6755588P			Wrench-Holding, 32/64 Pitch 24 Tooth Spline	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$918.66/Ea	\$1,837.32
7	199574	RB6795614P			Puller/Pusher Idler Gear Support Shaft	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$538.00/Ea	\$1,076.00
8	199575	RB6795974P			Torquemeter Shaft Alignment Tool	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$860.00/Ea	\$1,720.00
9	199576	RB6795984P			Power Turbine Holder Shaft	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$721.00/Ea	\$1,442.00

OCT 2 5 2019

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Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
10	199579	RB6796930P			Accessory Gear Box Install Plate	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$841.00/Ea	\$1,682.00
11	199580	RB6796946P			Install & Removal Accessory Gear Box Bearings Drift	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$353.00/Ea	\$706.00
12	199581	RB6796948P			Drift Install/Removal Accessories Gear Box	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$310.00/Ea	\$620.00
13	199582	RB6796949P			Accessory Gear Box Bearings Installation Drift	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$292.00/Ea	\$584.00
14	199583	RB6796966P			RET. RING, FUEL CTR. DR. PLIER	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$827.00/pcs	\$1,654.00
15	199584	RB6798047P			WRENCH OIL SUMP TURBINE	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$518.78/Ea	\$1,037.56
16	199585	RB6798807P			COMP. LUBE OIL FILTER POPP VAL	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$845.25/pcs	\$1,690.50
17	199586	RB6799518P			PULLER-GAS PRODUCER BALL BEARING LABYRINTH SEAL ASSEMBLY	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$792.00/pcs	\$1,584.00
18	199587	RB6799973P			PULLER SEAL POWER TURBINE BELLOWS TYPE	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$2,291.81/Ea	\$4,583.62
19	199588	RB6872165P			HELICAL DRV GEAR ASSY INTRNL CLRNC GAGE	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$2,058.00/pcs	\$4,116.00
20	199589	RB6872541P			PWR TURB SUPPORT PROTECTIVE CVR	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$380.27/pcs	\$760.54
21	199590	RB6872575P			RIGGING PIN	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$319.00/pcs	\$638.00

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22	199593	RB6872746P			Puller, Power Train Drive Gear Bearing	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$1,950.00/Ea	\$3,900.00
23	199594	RB6872880P			Compressor Mounting Inserts Checking Fixture	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$1,905.00/Ea	\$3,810.00
24	199595	RB6872927P			RED. GEAR FLANGED STUD WRENCH	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$340.64/pcs	\$681.28
25	199596	RB23006778P			GUIDE SPUR ADAPTER GEAR SHAFT	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$533.00/pcs	\$1,066.00
26	199597	RB23033033P			DRIFT GUIDED COMPRESSOR FRONT BEARING RING SEAL	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$858.75/pcs	\$1,717.50
27	199598	RB6795969P			Holder Torquemeter Shaft Support	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$765.86/Ea	\$1,531.72
28	199599	RB6796918P			Install Turbine & Exh Colct Support Oil Bellows Seal Dft	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$877.00/Ea	\$1,754.00
29	199600	RB6796941P			Seals Replacement, Accessories Gear Box	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$4,053.00/Ea	\$8,106.00
30	199601	RB6796950P			Accessory Gear Box Bearing Puller	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$3,698.00/Ea	\$7,396.00
31	199602	RB6798292P			Wrench Ground Idle Screw Adjusting (Hinged)	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$623.21/pcs	\$1,246.42
32	199603	RB6798927P			Compressor Impeller Assembly	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$1,185.00/Ea	\$2,370.00
33	199604	RB6799955P			Fixture-Assembly Turbine	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$2,598.41/Ea	\$5,196.82

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34	199605	RB6872879P			SPOTFACING FIXTURE	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$743.50/pcs	\$1,487.00
35	199606	RB6872881P			COMPR MTG INSERT WRENCH	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$327.00/pcs	\$654.00
36	199608	RB6872882P			Turbine Front Bearing Puller	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$3,399.00/pcs	\$6,798.00
37	199610	RB6886201P			POWER TAKEOFF ROLLER BEARING GUIDE	Firmed x2	-	11/11/19	2 pcs	0 pcs	2 pcs	\$904.00/pcs	\$1,808.00
38	199611	RB6798316P			ADAPTER TURNOVER STAND	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$807.00/Ea	\$1,614.00

Grand Total: \$88,020.94

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

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35		RB6872881P			COMPR MTG INSERT WRENCH	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$327.00/pcs	\$654.00
36		RB6872882P			Turbine Front Bearing Puller	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$3,399.00/pcs	\$6,798.00
37		RB6886201P			POWER TAKEOFF ROLLER BEARING GUIDE	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$904.00/pcs	\$1,808.00
38		RB6798316P			ADAPTER TURNOVER STAND	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$807.00/Ea	\$1,614.00

Grand Total: \$88,020.94

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A005 RIGHT OF ENTRY

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A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 8/23/19 1:22 PM Dart.Lavoie.Chantal



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB044334

Dated: 10/23/2019

Our Order / Job No: AWT-HB044334 A26

Order Qty: 2

Part Name: DRIFT GUIDED COMPRESSOR FRONT BEARING RING SEAL

Part Number RB23033033

Lot Size: N/A

Ship Date: 10/23/2019

~~We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:~~

Drawing Number: RB23033033

Rev: 2

Material Size and Type: -1, -2/ 4140 STEEL

Material Specifications: STEEL: ASTM A108

Heat Treatment: 47 RC

Plating/Finish: BLACK OXIDE: QMSI-6.2.2 B.O. REV-D

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date:

10/23/19

Signed:

Harriet M. Felt

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com



Bill to: DART AEROSPACE
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

DART AIRSPACE LTD